

Date: Thursday, 6/21/2007 2:29:25 PM  
 User: Kim Johnston

## Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEB
Job Number :	33062		
Estimate Number :	10498		
P.O. Number :	N/A	Part Number :	D2739
This Issue :	6/21/2007	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2739 REV C
First Issue :	N/A	Project Number :	N/A
Previous Run :	32989	Drawing Revision :	C
		Material :	N/A
Written By :		Due Date :	7/10/2007
Checked & Approved By :	Qty: 8		Um: Each
Comment :	Type : LANDING GEAR Est Rev: C 02.11.28 Reformat : KJ Est Rev: D 06-03-21 As Per Rev C JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26005108	Extrusion 'I Beam' thin
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Comment: Qty: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Extrusion 'I Beam' thin

Pick:

Qty	Part Number	Description	Batch
1	D2600-5	Web	B29785

507-7-10

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2739.

2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739

3-Use uni-bit to open holes to finish size as per Dwg D2739.

4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends.

5-Deburr

507-7-10

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

DP 2-2-10

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

507-7-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   P   Date: 07/07/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:29:25 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 33062

Part Number: D2739

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Handwritten: 7-7-10*

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock

Location: *L6*

*Handwritten: JB 7-7-10*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten: 06/21/07/11*

Job Completion



*Handwritten: ll 07-07-11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

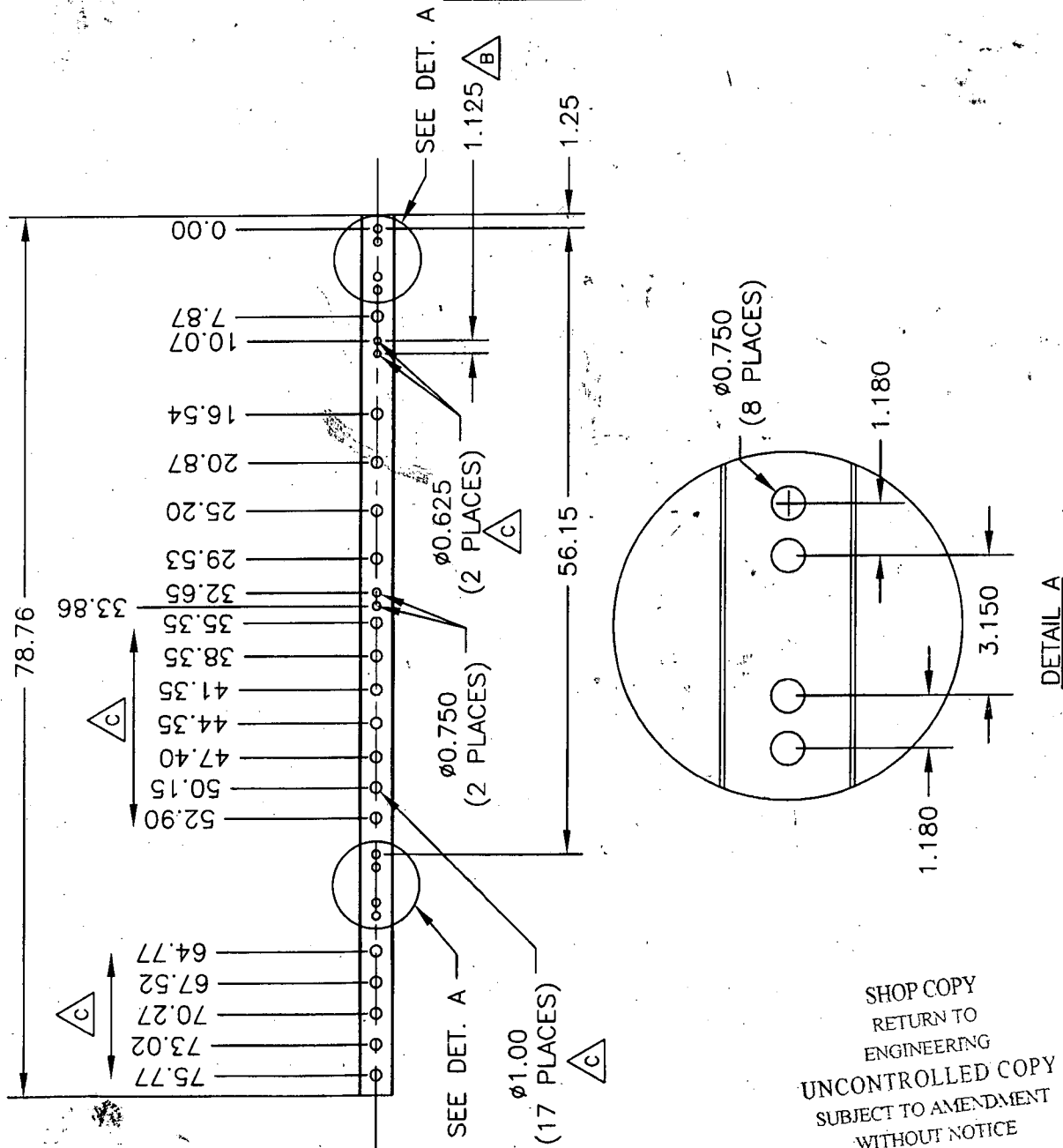
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries.

**DART****RELEASED**  
de-02-07

DESIGN RH	DRAWN BY RH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2739	REV. C SHEET 1 OF 1
DATE 06.01.05	TITLE WEB	SCALE 1:15	
A	98.04.16	NEW ISSUE	
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS	
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS	



SHOP COPY  
RETURN TO  
ENGINEERING  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **33062**

- D2739 WEB
- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION  
2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
3) ALL DIMENSIONS ARE IN INCHES  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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